

Work Order ID 82024

82024

Page 1

March-22-12 10:22:14 AM

Item ID: D3417-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Washer
 Start Date: 22/03/2012 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 05/04/2012 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: M L J Date: 12/03/22 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3417	Rev. <i>EF</i>								
100	Hardinge CNC LATHE SMALL	0.00							
100									
Doosan	Memo	0.00							
Doosan Lathe	1-Turn as per Folio FA761 Rev: _____ & Dwg D3417 Rev: _____ 2-Deburr								
			<i>SA</i>	<i>12/3/28</i>					
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control			<i>SA</i>	<i>12/3/28</i>					
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control			<i>OK</i>	<i>12/03/28</i>					

40 *φ*

40 *φ*

40 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: ST 42	0.00							
130									
Packaging	Memo	0.00							
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

40x SP 12-03-30

12/3/30

CA 12/03/30

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Picklist Print

March-22-12 10:22:18 AM

Page 1

Work Order ID: 82024

82024

Parent Item: D3417-5

D3417-5

Parent Item Name: Washer

Start Date: 22/03/2012

Required Date: 05/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP Rev:ANew issue08-07-09 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDEL RINR1.2500		Purchased	No			110	f	16.5320	0.0296	1.246316			

MDFI RINR1 2500

DEL RIN ROUND BAR 1.25"

**

SD 12/3/28

Location

Loc Qty

Loc Code

MAT055

16.532

114586

1.449

119133

15.083

2.0 Pf

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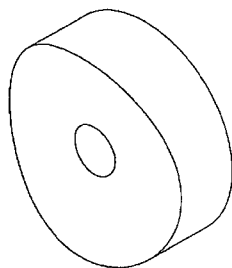
Dart Aerospace Ltd

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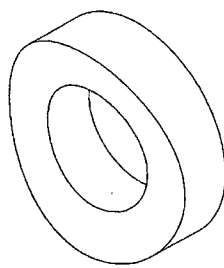
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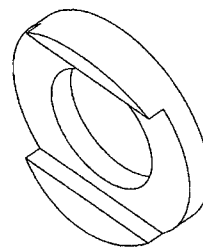
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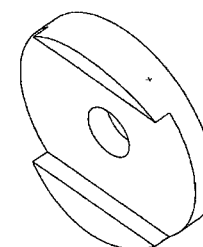
D3417-1 WASHER



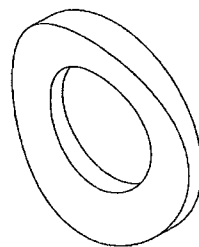
D3417-3 WASHER



D3417-5 WASHER



D3417-7 WASHER



D3417-9 WASHER

NOTES:

- 1) MATERIAL: BLACK DELRIN II 150E OR ACETRON GP ACETAL, ROD
REF DART SPEC M-DELIN-R
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, BAR
REF DART SPEC M-DELIN-B
OR BLACK DELRIN II 150E OR ACETRON GP ACETAL, SHEET
REF DART SPEC M-DELIN-S
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3417-1, 0.020 lbs
D3417-3, 0.010 lbs
D3417-5, 0.010 lbs
D3417-7, 0.010 lbs
D3417-9, 0.004 lbs

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 82024 MLT

12/03/22

RELEASED
2010-09-15

F	ADD D3417-9 (ZN B5-3)	SC	10.07.26
E	ADD D3417-7 (ZN A2-2)	RF	09.06.30
D	ADD -5 WASHER (ZN B2-1, B2-2); REFORMAT TO "B" SIZE & UPDATE TO CURRENT STANDARDS; REASON: INSTALLATION OF NEW TOW RING	AJS	08.07.08
C	REMOVE CBORE, WIDEN	PH	05.06.30
B	CHANGE TO ROUND WASHER	PH	05.06.10
A	NEW ISSUE	PH	05.03.31
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D3417	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WASHER	NTS
DATE	10.07.26	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED TO THE CUSTOMER ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED IN ANY OTHER MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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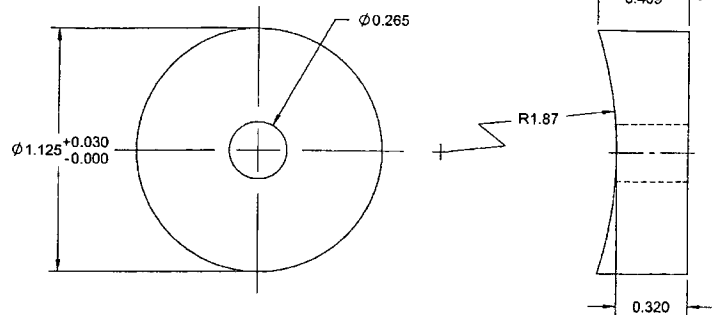
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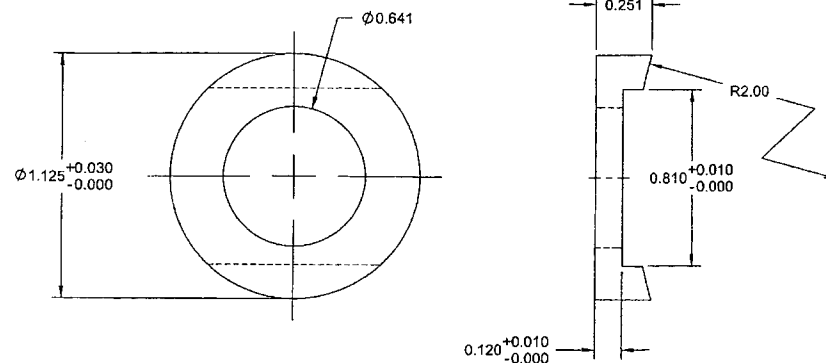
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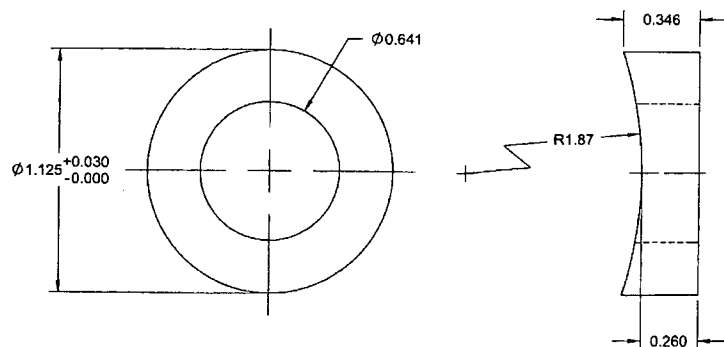
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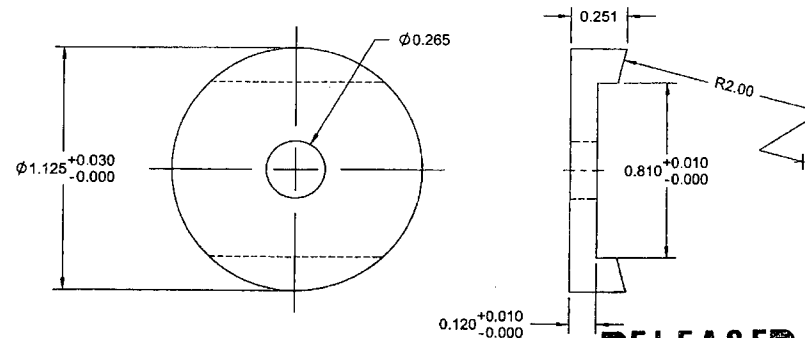
D3417-1 WASHER



D3417-5 WASHER



D3417-3 WASHER



D3417-7 WASHER

RELEASED
2010-09-15

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CHECKED		DRAWING NO. D3417	REV. F
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE WASHER	SCALE NTS
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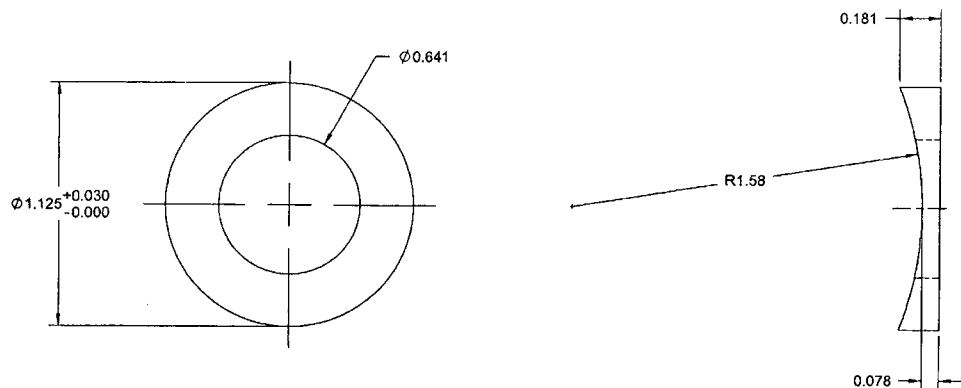
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D3417-9 WASHER



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